

Date: Thursday, 15/01/2009 11:13:33 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 44785	
<b>Estimate Number</b> : 11285	
<b>P.O. Number</b> :	<b>Part Number</b> : D34361
<b>This Issue</b> : 15/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3436 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 42321	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/01/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09.01.15</u>	
<b>Comment</b> : Est: A 05.05.10 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M4130NT2500W063	4130 RD tube 2.50 x .063wall
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**Comment:** Qty.: 0.1531 f(s)/Unit Total : 0.9185 f(s)

4130 tube 2.5"OD.063wall

Cut material : AISI 4130N Steel tubing MIL-T-6736, AMS 6371, 6360,6361,6362,6373 or 6374 to 1.750" as per Dwg D3436

(M4130N-T2500W063) -

Identify as D3436-1

\*Batch: M17678 Dwg Rev. A

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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(X6)

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr & Fillet ID 0.030" as per Dwg D3436

Plc 09.01.26

3.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5 09.01.26 (X6)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: Carl L.

18 09.01.26 (X6)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

09.01.26 df

Job Completion



u 09.01.26

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

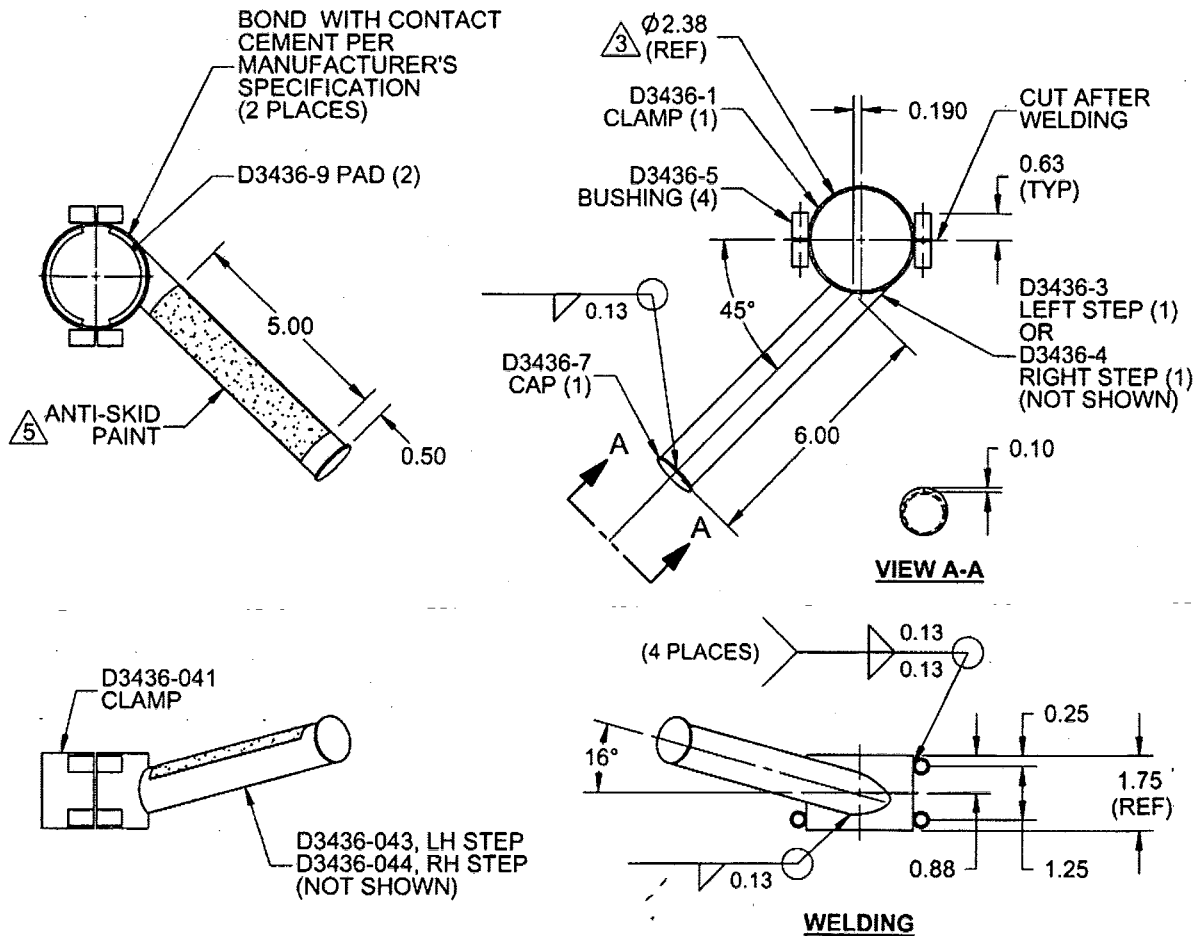
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**DART**

DESIGN MB	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3436</b>	REV. A SHEET 1 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:4
A	05.04.28	NEW ISSUE	

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005.4.18
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005.4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.05.27

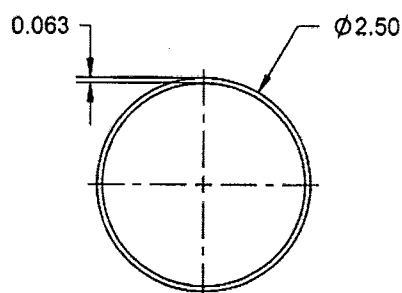
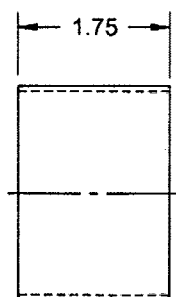
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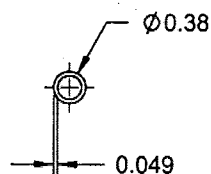
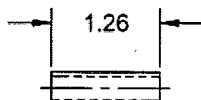


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DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**

05-05-27 *[Signature]*

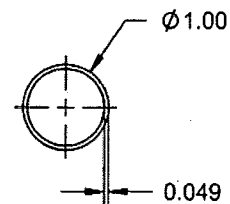
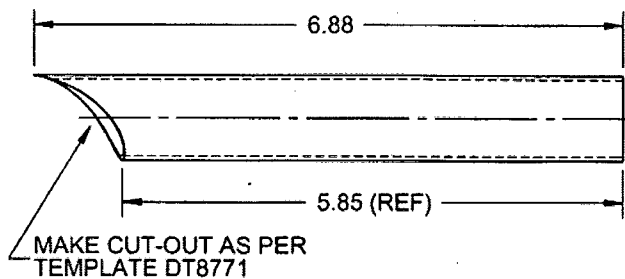
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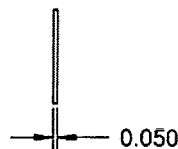
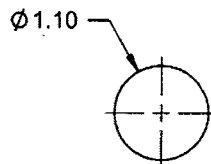
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DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2

**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

**RELEASED**05-05-27 *[Signature]***D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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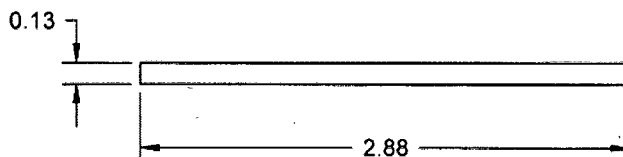
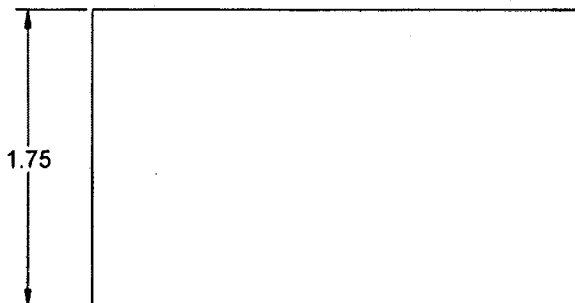
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DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:1



**RELEASED**  
05-05-27 *[Signature]*

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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